

Work Order ID 62054

Wednesday, September 15, 2010 1:28:37 PM



Page 1

Item ID: D2804-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per File D2804-1-2_Blank Dwg Rev: Prog Rev: 2-Deburr if necessary								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per folio FA103								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10-9-15

(4)

10-9-15

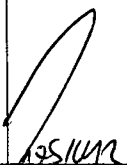
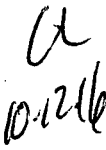



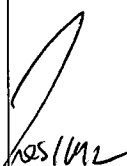
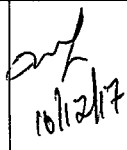

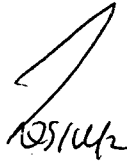

10/12/15

4

10/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-1 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: _____ Date: 10/12/16
 Resolution: rework Disposition: rework QA: N/C Closed: _____ Date: 11/01/12

NCR: <u>62054</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/16	# 110	Found at assembly that 211 (Qty 4) were machined to 2 wrong all parts are -2. not -1		- Create a w/o to make -2. ADD all in for from this to w/o B <u>64769</u> - FAZ P# is correct.	 10/12/16	 11/12/12	 12/5/12	 10/12/16
		211 operator mixes up parts when looking at his schedule. Lack of attention		- Please remake -1 parts on this w/o.	 10/12/17	 11/01/12	 12/5/12	 10/12/16

NOTE: Date & initial all entries

Work Order ID 62054



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Wednesday, September 15, 2010 1:28:37 PM

Item ID: D2804-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		A. A 10/12/20		4	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		10-12-16	
150 Packaging Packaging	Identify as per dwg & Stock Location: C-A w/o B61726 Memo	0.00 0.00							9/10/12/20 (E) 11/01/11 (E)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 62054

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Item ID: D2804-1 Accept  Setup Start 
Revision ID:
Item Name: Bracket Stop 
Start Date: 9/15/2010 Start Qty: 4.00  Cust Item ID:
Required Date: 9/22/2010 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/01/12 	

MF
11-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 1:28:41 PM

Page 1

Work Order ID: 62054

Parent Item: D2804-1

Parent Item Name: Bracket



Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A ☐ 00.11.06 ☐ New Issue ☐ EC ☐
 IPP B ☐ 06.05.30 Blanks on wtjet ☐ EC ☐
 IPP Rev: C As per Rev C 06-11-09 JLM
 IPP Rev: D Removed Tumbling 08-09-09 JLM Verified By: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X12.00 0		Purchased	No			100	f	36.0000	0.75	3.157895			



1810-9-15

6061-T6 Bar .500 x 12.00

10.00
 9/10-9-16

Location

Loc Qty

Loc Code

MAT07

36

111382

36

111382

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 62054 62054
Description: STA 155 Bracket		Part Number: D2804-2
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

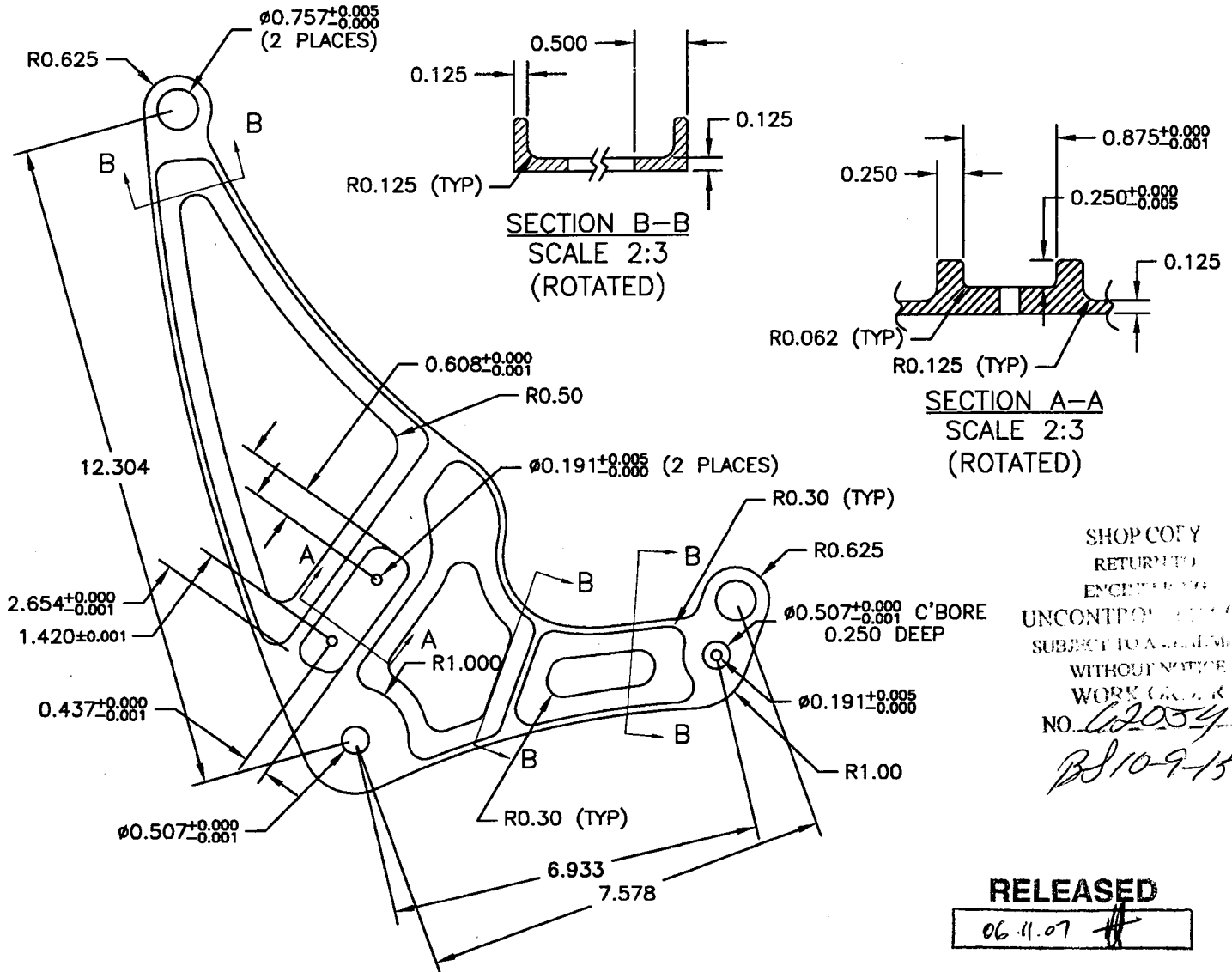
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	—		Vern	ML-7
0.125	+/-0.010	.126	—		"	"
R0.125	+/-0.010	R.125	—		Rad-gage	REF
0.250	+/-0.010	.249	—		Vern	ML-7
0.250	+0.000/-0.005	.248	—		Depth-gage	ML-05
0.875	+0.000/-0.001	.875	—		Micro	ML-01
R0.062	+/-0.010	R.062	—		Rad-gage	REF
Ø0.757	+0.005/-0.000	Ø.760	—		Vern	ML-7
R0.625	+/-0.010	R.625	—		"	"
12.304	+/-0.005	12.304	—		M-tape	ML-2
Ø0.507	+0.000/-0.001	Ø.5068	—		Micro	ML-01
0.437	+0.000/-0.001	.437	—		Vern	ML-7
0.608	+0.000/-0.001	.608	—		"	"
Ø0.191	+0.005/-0.000	Ø.193	—		"	"
1.420	+0.001/-0.001	1.419	—		"	"
0.250 deep	+/-0.010	.247	—		"	"
6.933	+/-0.005	6.933	—		"	"
7.578	+/-0.005	7.578	—		"	"
0.500	+/-0.010	.501	—		"	"

Measured by: <i>mf</i>	Audited by: <i>D.A</i>	Prototype Approval:	N/A
Date: 10/12/17	Date: 10/12/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM <i>JA</i>	<i>BE</i>

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. C
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 1 OF 2
				D2804	
DATE	06.10.16			TITLE	SCALE
				STA 155 BRACKET	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE			

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

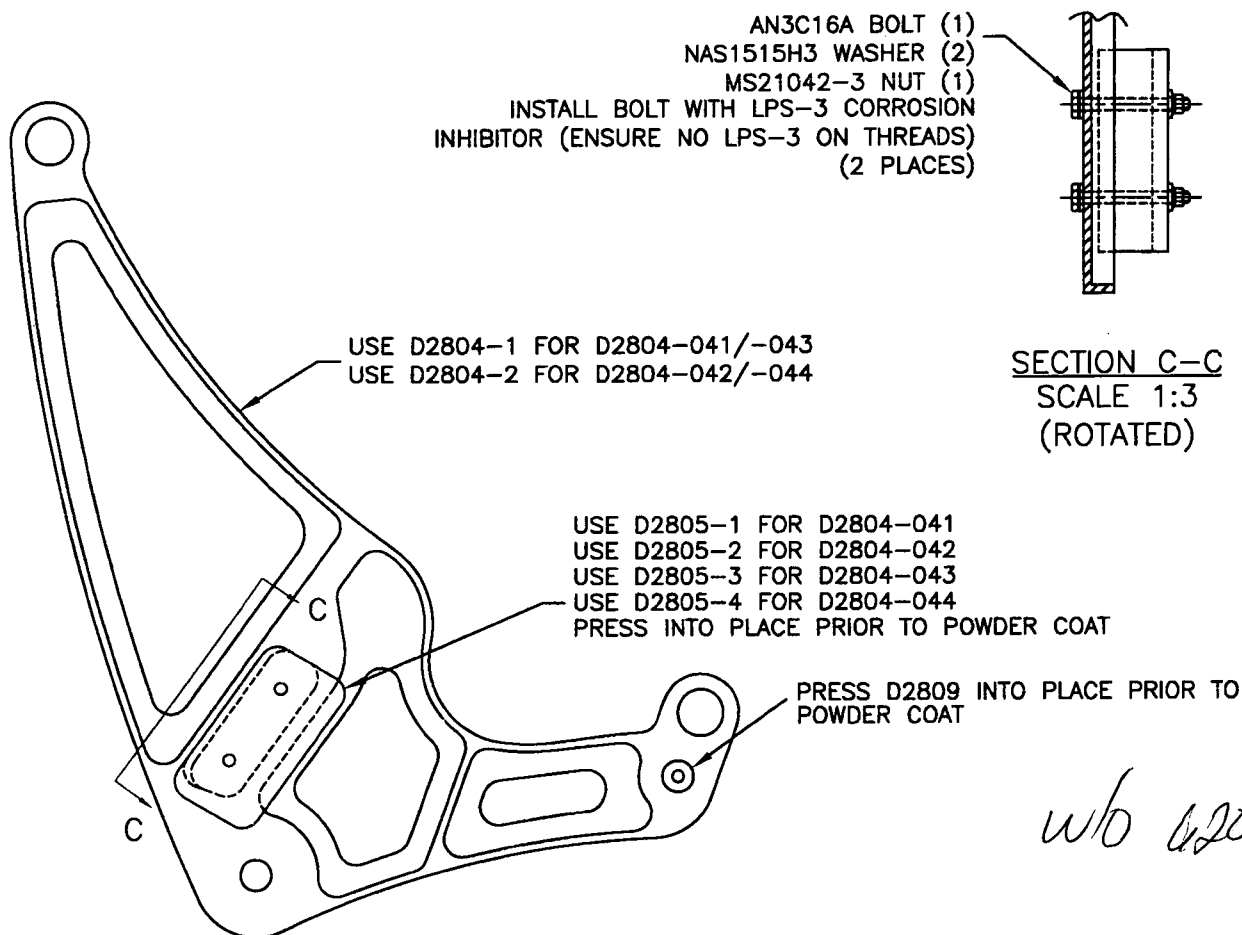
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



RELEASED

06.11.07

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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